

54393 Deren

Work Order ID 52348

Tuesday, September 22, 2009 12:26:16 PM



Page 1

Item ID: D2668-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Aft In 206

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2668	Rev D								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 3-Fixturing Inspection last completed on 09/12/02 by mmf
☐ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 5-Machine Step No 2 of F

4 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

mmf 09/12/02

4 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mmf 09/12/02






4 0



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Item ID: D2668-1 Accept  Setup Start 
Revision ID: D Stop 
Item Name: Saddle, LH Aft In 206
Start Date: 9/23/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 10/9/2009 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	MK 09/12/07			4	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BK 09-12-7			(4)			
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00	M 11/2/08						
START TIME: 12:00 320° FINISH TIME: 12:30.		OVEN TEMPERATURE: 12:30.		BK 09-12-7		(4)			

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Item ID: D2668-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Aft In 206

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/12/07

K4

Ø

170

Identify as per dwg & Stock Location: 427

0.00



Packaging

Memo

0.00

Packaging

09/14/08

4

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08

mf

09-12-07

Picklist Print

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Page 1

Work Order ID: 52348



Parent Item: D2668-1RevD



Parent Item Name: Saddle, LH Aft In 206

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001RevB		Manufactured	No			100	Each	0.0000	4.0000			

Saddle Billet

B 46409

X 4

mt= 09/12/09

DART AEROSPACE LTD	Work Order: 52348
Description: 206 Saddle, Inboard, Left side	Part Number: D2668-1
Inspection Dwg: D2668 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.109	.111	.108	.108		
B	0.100	0.140		.125	.126	.126	.126		
C	1.125	1.145		1.134	1.134	1.134	1.133		
D	0.615	0.685		.662	.656	.659	.660		
E	0.240	0.260		.251	.247	.247	.247		
F	1.313	1.343		1.328	1.325	1.325	1.325		
G	0.210	0.220		.227	.224	.220	.224		
H	0.100	0.180		.128	.134	.132	.137		
I	2.470	2.510		2.493	2.490	2.490	2.493		
J	1.565	1.585		1.570	1.571	1.571	1.570		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.113	.115	.115	.115		
M	0.990	1.010		.998	.999	.999	.997		
N	0.510	0.515		.511	.511	.511	.511		
O	5.990	6.010		6.004	6.004	6.004	6.005		
P	1.245	1.255		1.247	1.247	1.247	1.247		
Q	2.495	2.505		2.497	2.497	2.498	2.497		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	1.995	2.005		1.999	1.999	1.999	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.363		
V	0.787	0.807		.802	.798	.798	.801		
W	1.040	1.060		1.050	1.049	1.050	1.049		
X	1.674	1.684		1.680	1.679	1.680	1.680		
Y	0.257	0.262		.260	.260	.260	.260		
Z	0.912	0.932		.918	.918	.920	.918		
AA	0.490	0.510		.498	.496	.495	.496		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	mmk
Date:	07/12/02

Audited by:	mmk
Date:	07/12/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

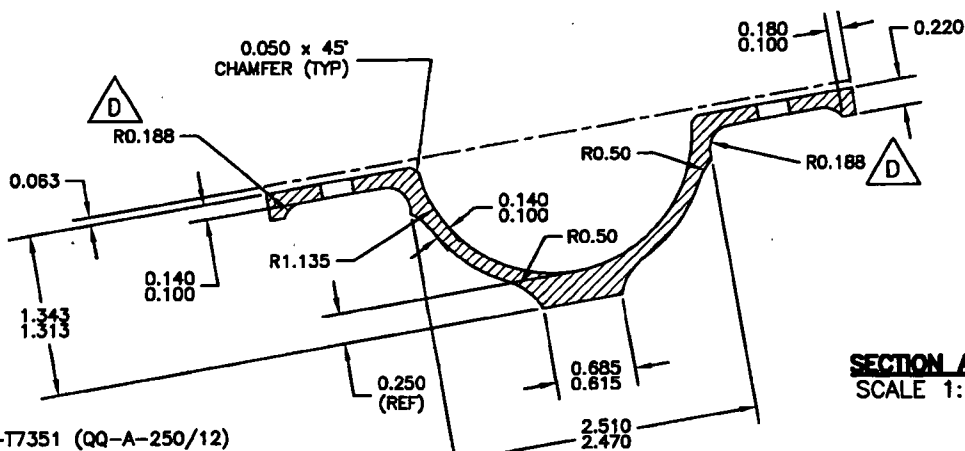
DART

DESIGN	<i>A</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>A</i>	DRAWING NO.	REV. D
				D2668	SHEET 1 OF 1
DATE				TITLE	SCALE
06.11.08				SADDLE AFT INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; ϕ 0.316 WAS ϕ 0.313			

RELEASED

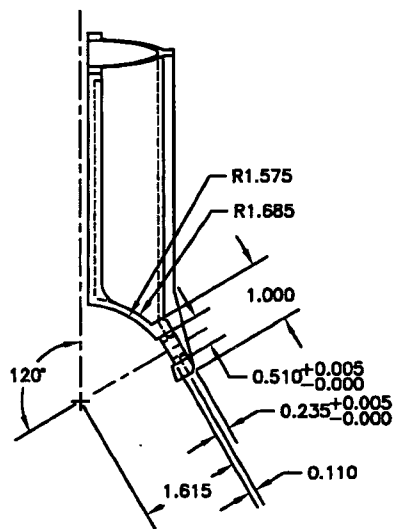
07.02.12 *A*

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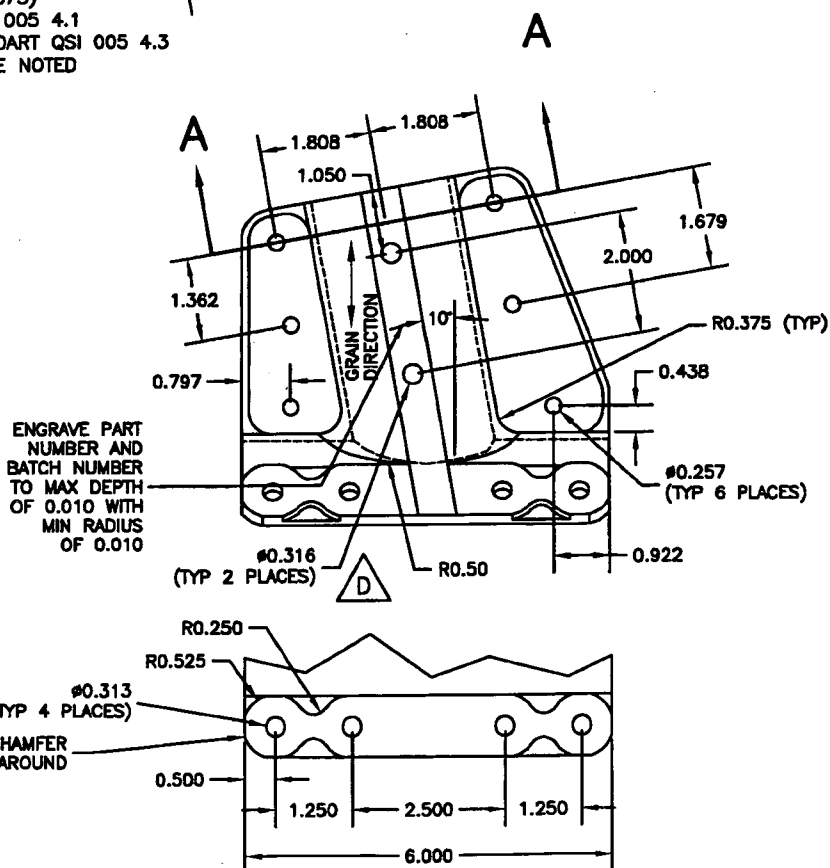


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2668-1 SHOWN (D2668-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2668-1 SADDLE AFT INSIDE HIGH



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